

DL102-013

Work Order ID 163822***163822***

Page 1

Item ID: D3500-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle

Start Date: 7/18/2017 Start Qty: 24.00

24

Cust Item ID:

Required Date: 7/28/2017 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan:  Date: JUL 10 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3500	C								

100

2.84

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

6.12

Program Batch No. 163822 Double check by: Kt 1-Machine Step No 1
per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step
No 2 per Folio FA641 and inspect per attached Dimension Sheets3-Machine
Step No 3 per Folio FA641 and inspect p

24  17-07-29

110

0.00

110

QC

Quality Control

QC1- Inspection performed by CMM

Memo

0.24

Inspect on CMM as per folio CMMA031.
DWG REV: C
CMM PROG. REV: AA

24  17-07-29

120

0.00

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.48

24  **DAS 49**
17/08/01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Work Order ID 163822

Monday, July 10, 2017 11:55:52 AM

163822

Page 2

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle
Start Date: 7/18/2017 Start Qty: 24.00 ***24*** Cust Item ID:
Required Date: 7/28/2017 Req'd Qty: 24.00 ***24*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 1.34				(24)	✓	2017-08-08 JSL BFB	
140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 8:05 OVEN TEMPERATURE: FINISH TIME: 8:55	0.00 0.74				24	✓	17-08-25 333	
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.24				24		DAS 38 AUG 28 2017	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Work Order ID 163822

Monday, July 10, 2017 11:55:52 AM

163822

Page 3

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle
Start Date: 7/18/2017 Start Qty: 24.00 ***24*** Cust Item ID:
Required Date: 7/28/2017 Req'd Qty: 24.00 ***24*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: 57406	0.00							
160									
Packaging	Memo	0.24			DAS 6 9-89	24	AUG 2 9 2017		ul
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	2.40							17/9/5
Quality Control									17/9/5

DAS
21
9-89 **AUG 2 9 2017**

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due								
		OTHER :							

Picklist Print

Monday, July 10, 2017 11:55:50 AM

Page 1

Work Order ID: 163822

163822

Parent Item: D3500-1

D3500-1

Parent Item Name: Saddle

Start Date: 7/18/2017

Required Date: 7/28/2017

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	11.0000	1	24			
D6102-013									**				
Saddle Billet													

kt 17-07-29

Location

MAT046

160144

Loc Qty

11

⑪

⑨

④

Loc Code

163266

164014

↑
Not in
stock list

Not
pulled
from
stock

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

DART AEROSPACE LTD				Work Order: 163822	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.483	0.490	Pin 0.484	0.484	0.484	0.484	0.484	0.484
B	1.175	1.185		1.180	1.180	0.484	0.484	0.484
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.580	1.582	1.581	1.580	1.580
J	0.240	0.260		0.253	0.252	0.251	0.251	0.252
K	0.490	0.510		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322	Pin 0.316	0.316	0.316	0.316	0.316	0.316
N	0.256	0.262	Pin 0.257	0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		5.999	5.999	5.999	5.999	5.999
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.546	0.545	0.548	0.546	0.547
V	0.793	0.803		0.795	0.795	0.795	0.795	0.795
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.109	0.109	0.109	0.109	0.109
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.257	0.257	0.257	0.257	0.257
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		0.252	0.252	0.252	0.252	0.253
AG	0.140	0.160		0.150	0.150	0.150	0.151	0.150
AH	0.140	0.160		0.152	0.152	0.152	0.152	0.152
AI	0.140	0.160		0.150	0.150	0.150	0.150	0.150
Accept/Reject				A	A	A	A	A

Measured by: Kx	DAS	Date: 17-07-29
Audited by:	49	Date: 17/08/01
Preliminary Approval:	9-89	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order:	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#6	#7	#8	#9	#10
A	0.483	0.490	Pin 0.484	0.484	0.484	0.484	0.484	0.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.580	1.580	1.580	1.584	1.580
J	0.240	0.260		0.252	0.253	0.250	0.252	0.252
K	0.490	0.510		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		0.316	0.316	0.316	0.316	0.316
N	0.256	0.262		0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		5.999	5.999	5.999	5.999	5.999
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.126	1.126	1.125	1.125
U	0.540	0.560		0.545	0.546	0.545	0.548	0.545
V	0.793	0.803		0.795	0.795	0.795	0.795	0.795
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.109	0.109	0.109	0.109	0.109
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.250	0.257	0.255	0.257	0.256
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.140	0.160		0.150	0.154	0.152	0.153	0.152
AH	0.140	0.160		0.152	0.150	0.151	0.152	0.150
AI	0.140	0.160		0.151	0.151	0.150	0.151	0.150
Accept/Reject				A	A	A	A	A

Measured by: KJ	DAS	Date: 17-07-30
Audited by: 49	9-89	Date: 17/08/01
Preliminary Approval:		Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order:	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
A	0.483	0.490	Pin 484	0.484	0.484	0.484	0.484	0.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.580	1.579	1.580	1.580	1.580
J	0.240	0.260		0.252	0.251	0.252	0.251	0.252
K	0.490	0.510	r	0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322	Pin 0.316	0.316	0.316	0.316	0.316	0.316
N	0.256	0.262	Pin 0.257	0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		5.999	5.999	5.999	5.999	5.999
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.546	0.545	0.547	0.548	0.546
V	0.793	0.803		0.795	0.795	0.795	0.795	0.795
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.109	0.109	0.109	0.109	0.109
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.256	0.256	0.256	0.256	0.256
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.140	0.160		0.149	0.156	0.150	0.150	0.152
AH	0.140	0.160		0.152	0.152	0.151	0.152	0.151
AI	0.140	0.160		0.150	0.150	0.150	0.150	0.150
Accept/Reject				A	A	A	A	A

Measured by: K+	DAS	Date: 17-07-30
Audited by: 49	9-89	Date: 17/08/01
Preliminary Approval:		Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order:	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
A	0.483	0.490	Pin 484	0.484	0.484	0.484	0.484	0.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.582	1.582	1.581	1.580	1.583
J	0.240	0.260		0.252	0.252	0.253	0.252	0.253
K	0.490	0.510		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322	Pin 0.316	0.316	0.316	0.316	0.316	0.316
N	0.256	0.262	Pin 0.257	0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		5.999	5.999	5.999	5.999	5.999
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.126	1.126	1.125	1.125
U	0.540	0.560		0.548	0.547	0.548	0.546	0.547
V	0.793	0.803		0.795	0.795	0.795	0.795	0.795
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.109	0.109	0.109	0.109	0.109
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.256	0.256	0.256	0.256	0.256
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.140	0.160		0.152	0.152	0.150	0.152	0.150
AH	0.140	0.160		0.156	0.151	0.152	0.156	0.152
AI	0.140	0.160		0.150	0.150	0.150	0.150	0.151
Accept/Reject				A.	A.	A.	A.	A.

Measured by: <i>KJ</i>	DAS	Date: 17-07-31
Audited by:	49	Date: 17/08/01
Preliminary Approval:	9-89	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order:	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

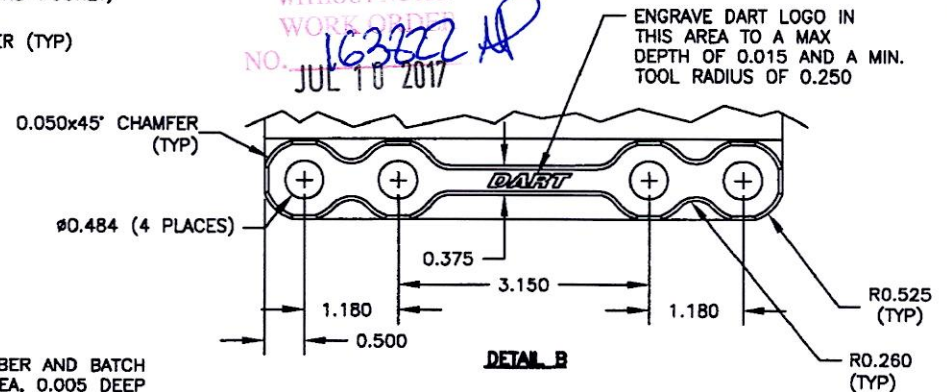
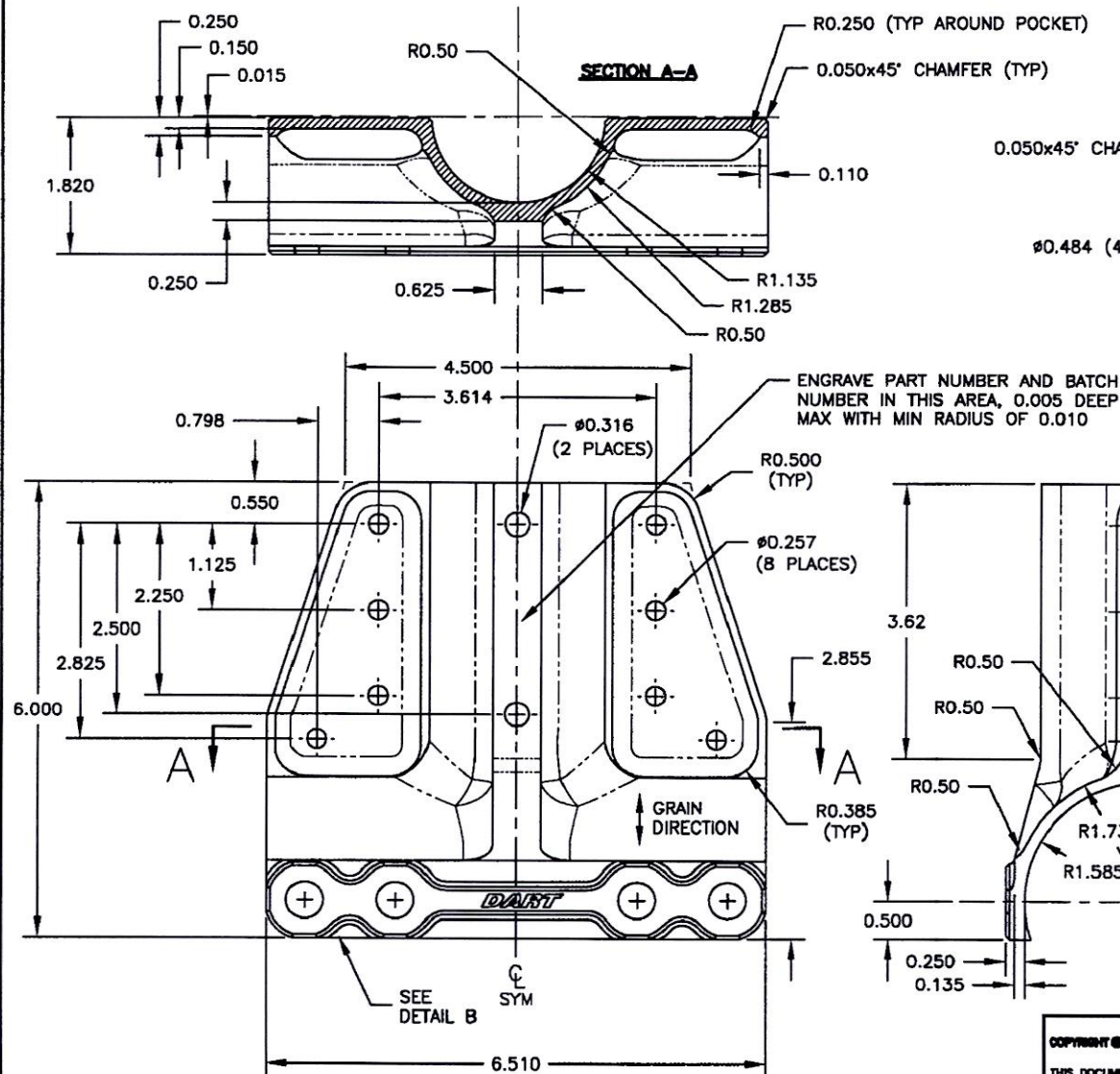
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	2 1	2 2	2 3	2 4	5
A	0.483	0.490	Pin 0.484	0.484	0.484	0.484	0.484	
B	1.175	1.185		1.180	1.180	1.180	1.180	
C	3.145	3.155		3.150	3.150	3.150	3.150	
D	1.175	1.185		1.180	1.180	1.180	1.180	
E	0.365	0.385		0.375	0.375	0.375	0.375	
F	0.490	0.510		0.500	0.500	0.500	0.500	
H	R0.515	R0.535		0.525	0.525	0.525	0.525	
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.581	1.582	1.584	1.585	
J	0.240	0.260		0.252	0.251	0.252	0.252	
K	0.490	0.510		0.500	0.500	0.500	0.500	
L	3.590	3.650		3.620	3.620	3.620	3.620	
M	0.315	0.322	Pin 0.316	0.316	0.316	0.316	0.316	
N	0.256	0.262	Pin 0.257	0.257	0.257	0.257	0.257	
O	6.500	6.520		6.510	6.510	6.510	6.510	
P	5.990	6.010		5.999	5.999	5.999	5.999	
Q	2.820	2.830		2.825	2.825	2.825	2.825	
R	2.495	2.505		2.500	2.500	2.500	2.500	
S	2.245	2.255		2.250	2.250	2.250	2.250	
T	1.120	1.130		1.125	1.125	1.125	1.125	
U	0.540	0.560		0.545	0.547	0.548	0.548	
V	0.793	0.803		0.795	0.795	0.795	0.795	
W	R.240	R.260		0.250	0.250	0.250	0.250	
X	0.040	0.060		0.050	0.050	0.050	0.050	
Y	0.100	0.120		0.109	0.109	0.109	0.109	
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	
AB	R.490	R.510		0.500	0.500	0.500	0.500	
AC	0.615	0.635		0.625	0.625	0.625	0.625	
AD	0.240	0.260		0.256	0.257	0.256	0.256	
AE	1.810	1.830		1.820	1.820	1.820	1.820	
AF	0.240	0.260		0.250	0.250	0.250	0.250	
AG	0.140	0.160		0.152	0.152	0.152	0.152	
AH	0.140	0.160		0.150	0.151	0.150	0.150	
AI	0.140	0.160		0.150	0.151	0.150	0.150	
Accept/Reject				A.	A.	A.	A.	

Measured by: K+	DAS	Date: 17-07-31
Audited by: 49	9-89	Date: 17/08/01
Preliminary Approval:		Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

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SUBJECT TO AMENDMENTS
WITHOUT NOTICE
WORK ORDER
NO. 163222
JUL 10 2017



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/B OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06-08-15

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C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	97	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	06.06.30	TITLE SADDLE
DRAWING NO. D3500		REV. C
		SHEET 1 OF 1
		SCALE
		2-3